

ABSTRACT

The present invention relates to a device and method for installing muntin bars and in particular a muntin grating, i.e. a muntin cross, into a frame, i.e. a spacer frame of an insulated glass window, comprising a device for realizing an accurate graded positioning of the muntin bars or the muntin grating within the spacer frame and also for an accurate junction provided there between. Said device further comprises a rectangular mounting frame having four frame pieces, which frame is inclined with respect to the vertical plane, and tie-bars movably supported by the frame for fixing and machining spacer frames of different sizes together with respective muntin bars, i.e. a respective muntin grating, and an apparatus for arranging and fixing said muntin bars or the muntin grating within the spacer frame of for example an insulated glass window. For such a device a method is proposed by means of which a plastic terminal plug is fixed within one end of a muntin bar, so that an end flange of the plug abuts against the inner side of the spacer frame, and fastening said plugs, i.e. the muntin bars fixed thereto at determined positions to the spacer frame profile by automatically screwing or shooting screws or shooting clamps in a program controlled manner which screws and clamps are provided respectively by means of a screwing apparatus or a shooting device movably supported relative to the spacer frame.